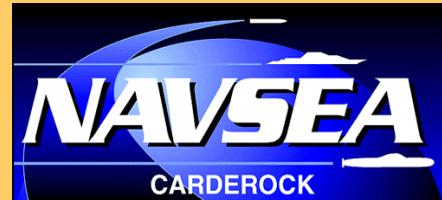


Electrospark Deposited Coating Technology for Naval Applications

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**Marine Corrosion Branch
West Bethesda, MD**



Report Documentation Page			<i>Form Approved OMB No. 0704-0188</i>	
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1. REPORT DATE SEP 2002	2. REPORT TYPE	3. DATES COVERED 00-00-2002 to 00-00-2002		
4. TITLE AND SUBTITLE Electrospark Deposited Coating Technology for Naval Applications			5a. CONTRACT NUMBER	
			5b. GRANT NUMBER	
			5c. PROGRAM ELEMENT NUMBER	
6. AUTHOR(S)			5d. PROJECT NUMBER	
			5e. TASK NUMBER	
			5f. WORK UNIT NUMBER	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Naval Surface Warfare Center, Carderock Division, 9500 MacArthur Boulevard, West Bethesda, MD, 20817-5700			8. PERFORMING ORGANIZATION REPORT NUMBER	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)			10. SPONSOR/MONITOR'S ACRONYM(S)	
			11. SPONSOR/MONITOR'S REPORT NUMBER(S)	
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release; distribution unlimited				
13. SUPPLEMENTARY NOTES 21st Replacement of Hard Chrome Plating Program Review Meeting, September 25-26, 2002, Toronto, Ontario. Sponsored by SERDP/ESTCP.				
14. ABSTRACT				
15. SUBJECT TERMS				
16. SECURITY CLASSIFICATION OF:			17. LIMITATION OF ABSTRACT Same as Report (SAR)	18. NUMBER OF PAGES 25
a. REPORT unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified	19a. NAME OF RESPONSIBLE PERSON	

OBJECTIVE AND APPROACH

Objective

- Produce good quality coatings using electrospark deposition (ESD)

Approach

- Identify Navy components for repair
- Develop ESD processing parameters
- Assess ESD coating quality

NAVY NEEDS

- Total ownership cost reduction
 - *Increase maintenance efficiency*
 - *Extend component service life*
- Increased readiness
 - *Reduce maintenance turn around times*
- Reduced environmental impact
 - *HAZMAT reduction*

ESD SYSTEM



ESD SYSTEM



POTENTIAL APPLICATIONS



Steering and Diving Control Rod



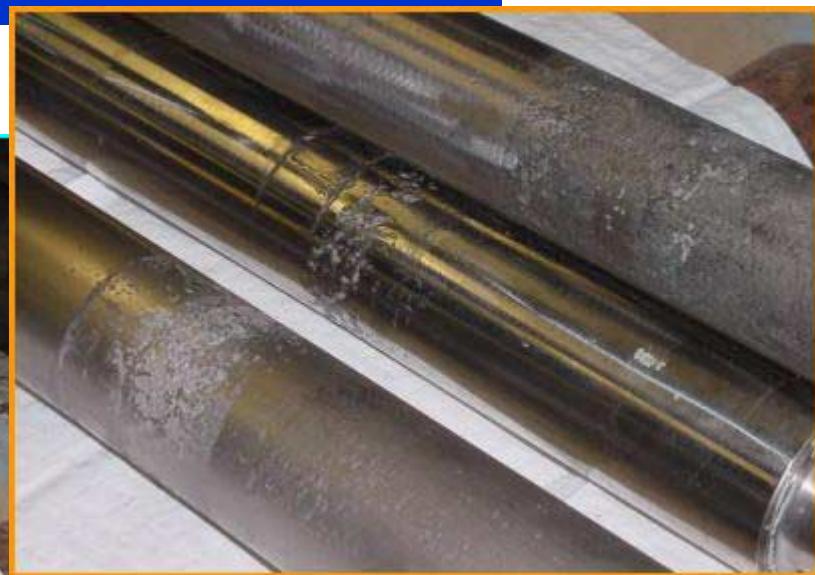
Steering and Diving Control Rod



Rubber Insulated Sound Isolation Coupling



Hull Valve Stem

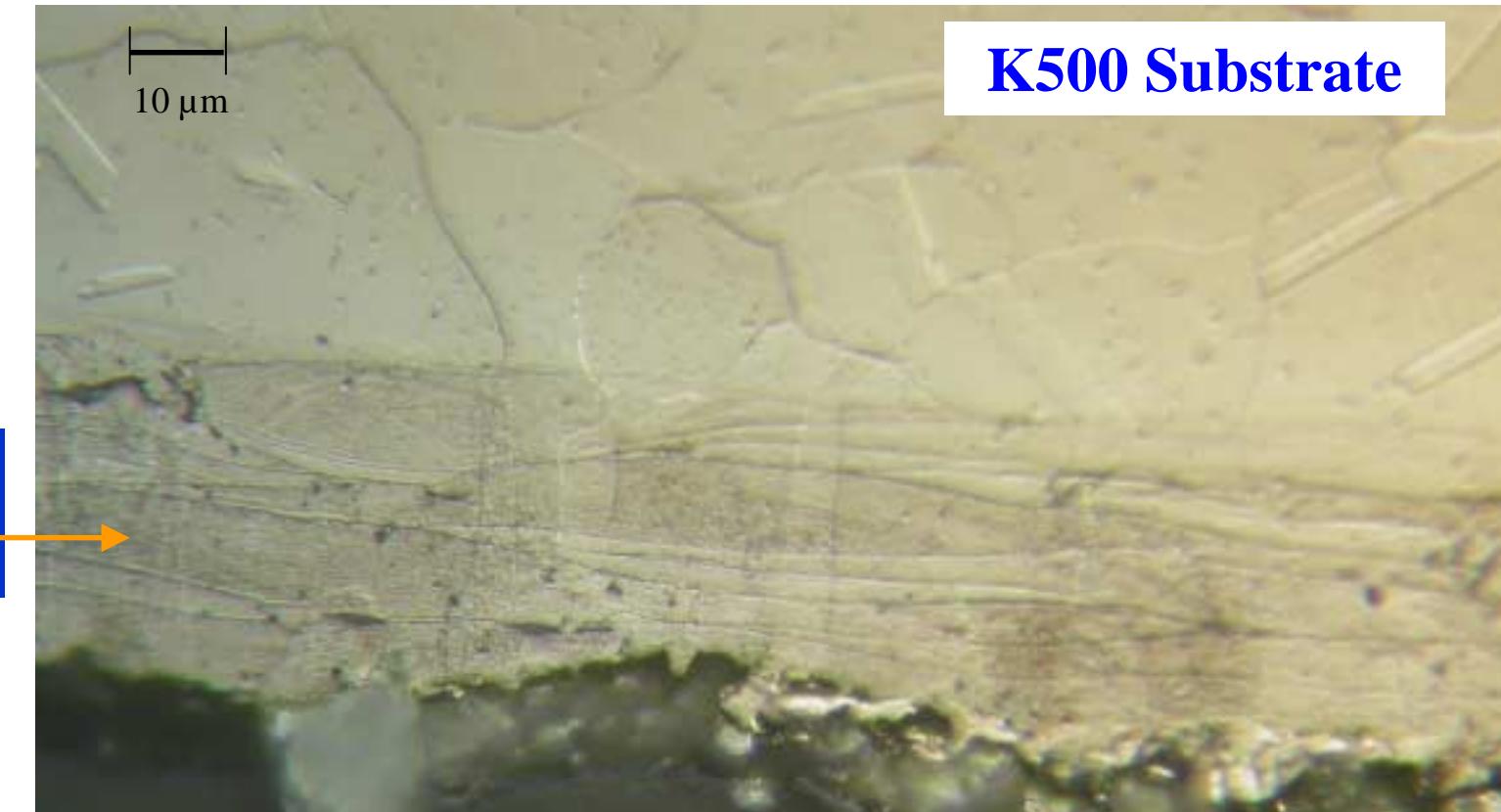


ESD COATINGS

- Alloy 400 (Ni-Cu)
- 70/30 Cu-Ni
- Ni-Cr-Mo Alloys
 - *Alloy 625*
 - *Alloy 59*
 - *Alloy C276*

ESD Alloy 400 on K500

ESD Alloy
400



ESD Alloy 400 on K500

ESD Coating :

Alloy 400

Hardness (VHN)

127

224

183

193

216

200

**Alloy 400 Hot Finished
Rod and Bar:**

VHN 140-250

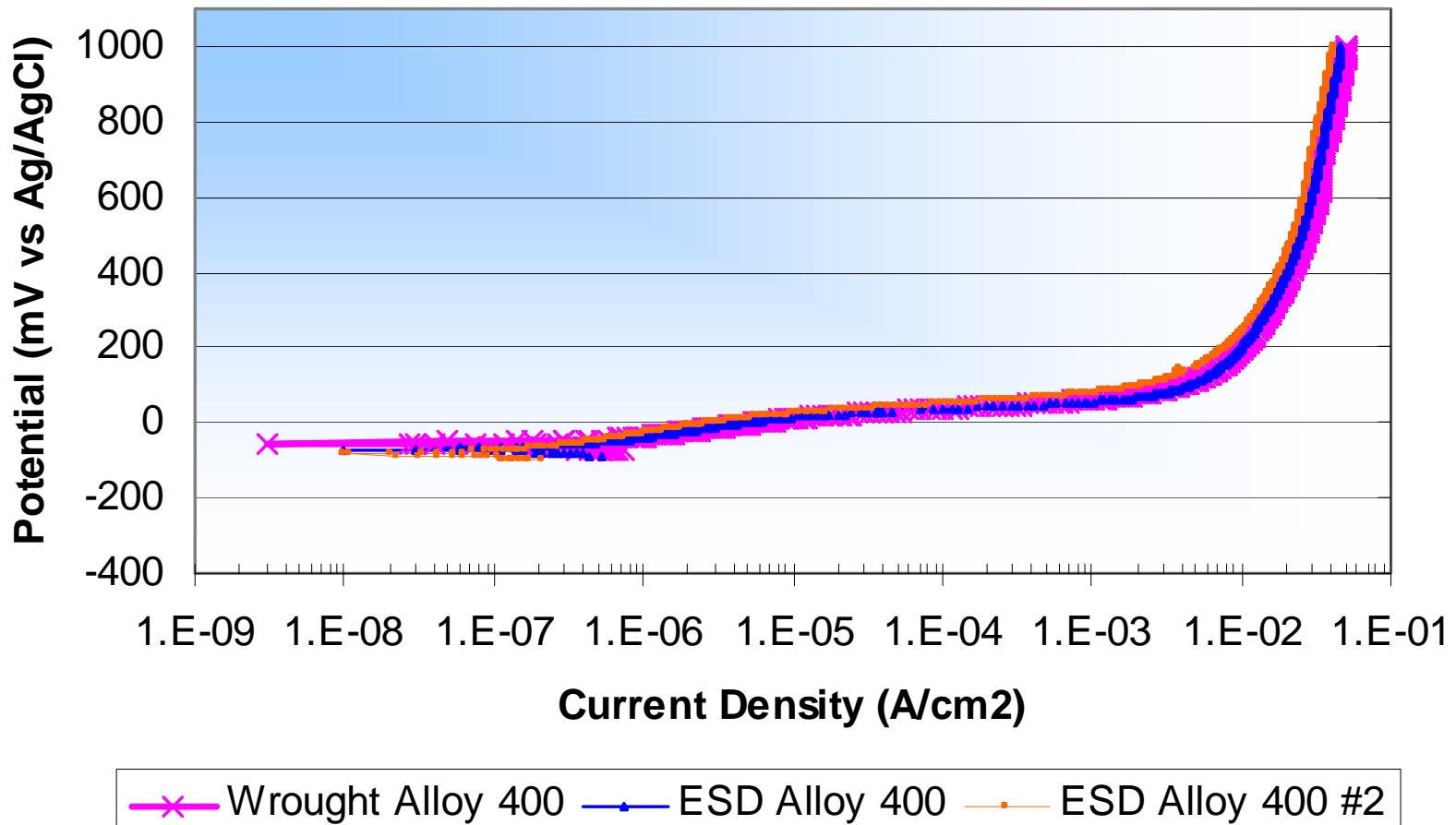
ESD Alloy 400 on K500

**K500 Hot Finished
& Aged Bar:**

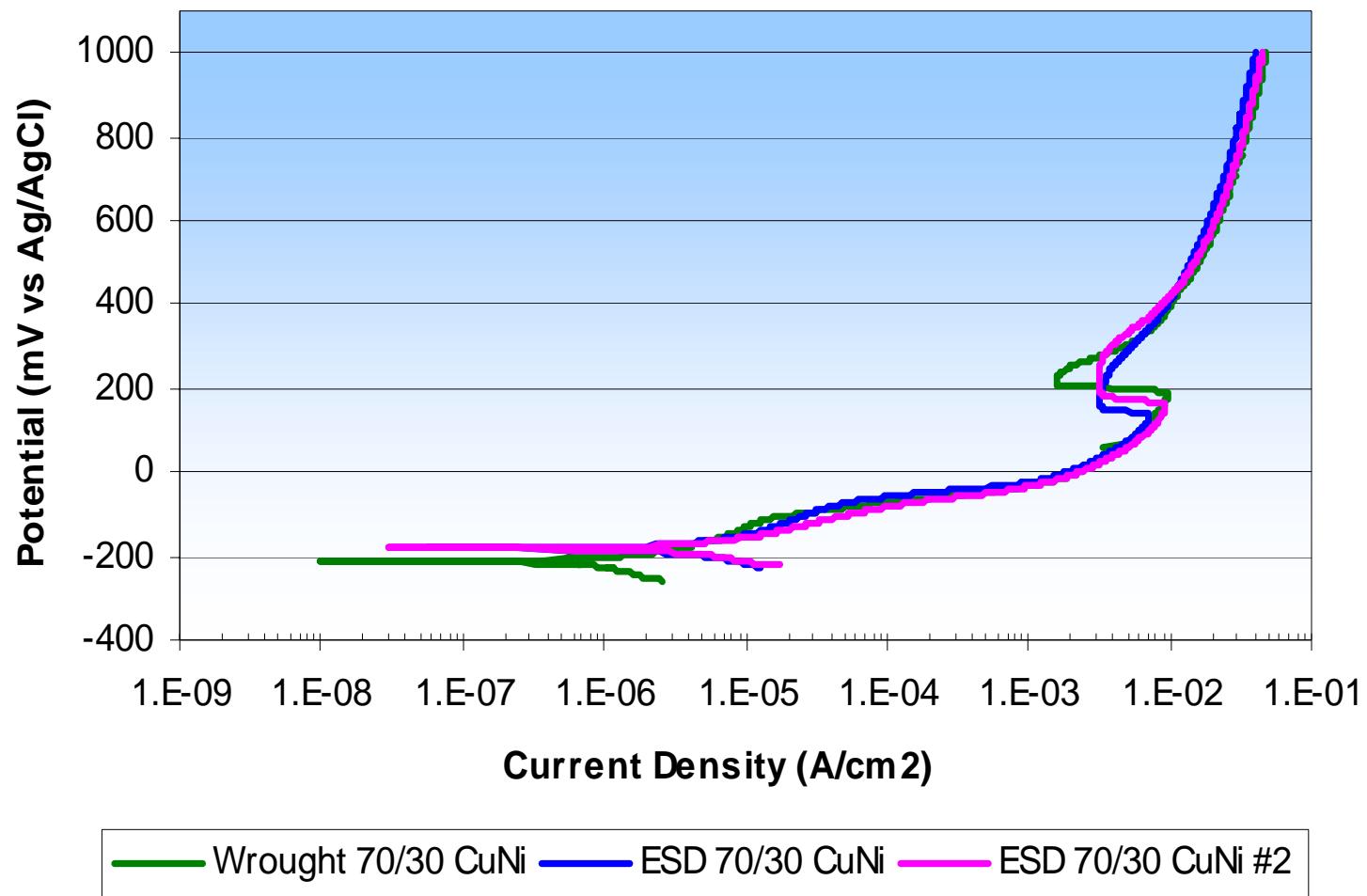
280-370 VHN

Alloy K500 Hardness (VHN)	Depth from Coating/Substrate Interface (um)
335	20
332	500
359	1000
338	1500
332	2000
338	2500

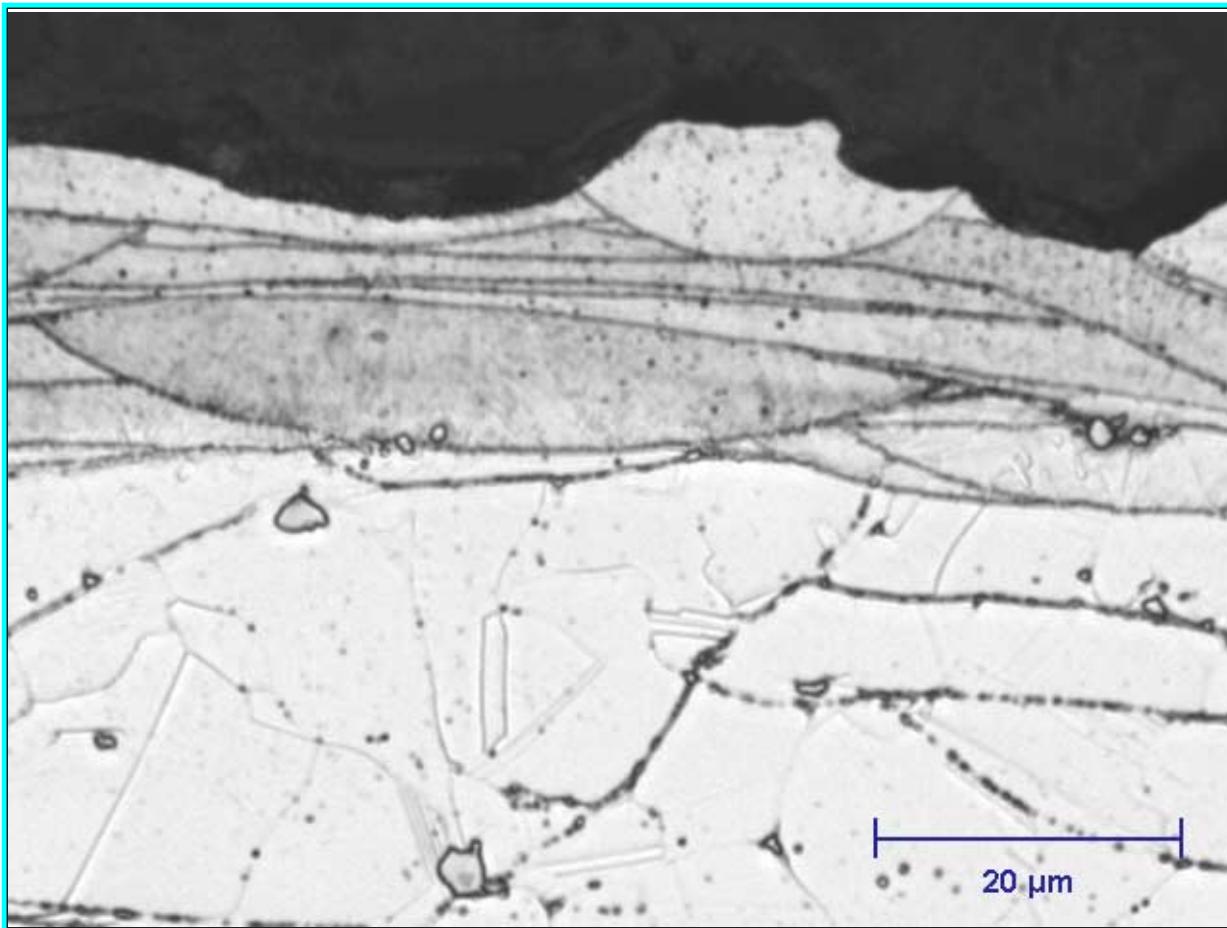
ESD Alloy 400 on K500



ESD 70/30 Cu-Ni on 70/30 Cu-Ni

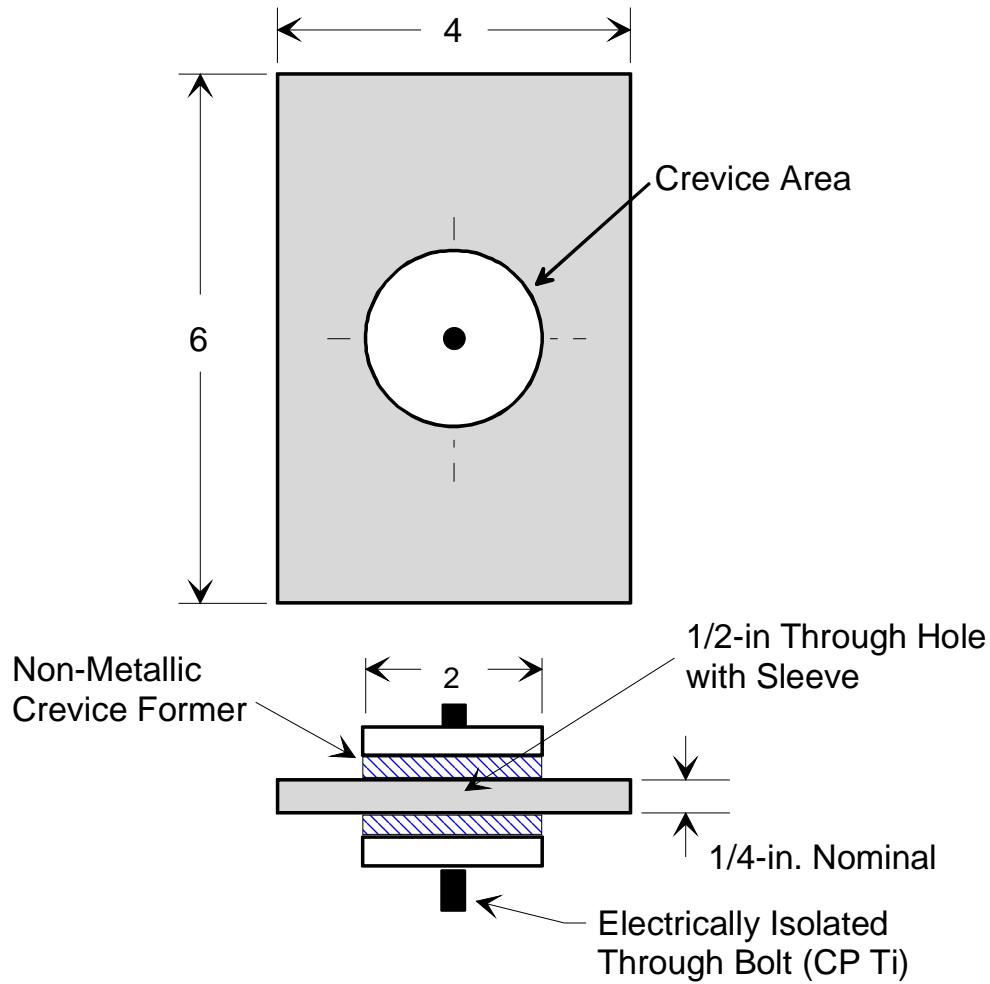


ESD Alloy 625 Coating



ESD of Ni-Cr-Mo Alloys on Alloy 625

Crevice Corrosion Testing in Natural Seawater



ESD of Ni-Cr-Mo Alloys on Alloy 625

Crevice Corrosion Testing in Natural Seawater



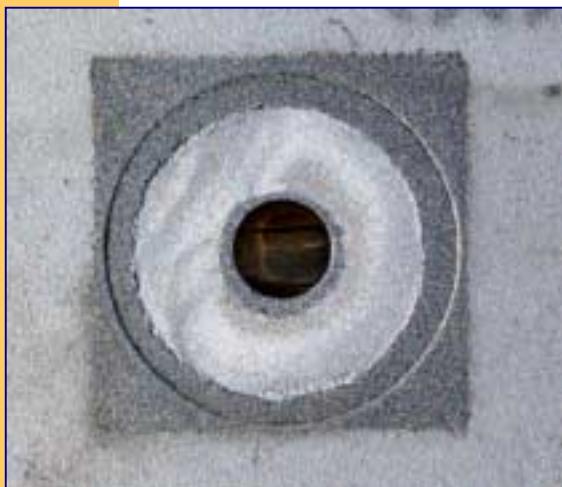
Ni-Cr-Mo Alloy Crevice Tests: 183 Days

Material	# of Initiated Sites	Time to Initiation (days)	Max Depth of Attack (mm)
Wrought 625	3	98, 161(2)	0.51
Wrought C276	0	---	0
Wrought 59	0	---	0
ESD 625	0	---	0
ESD C276	0	---	0
ESD 59	0	---	0

Ni-Cr-Mo Alloy Crevice Tests: 365 Days

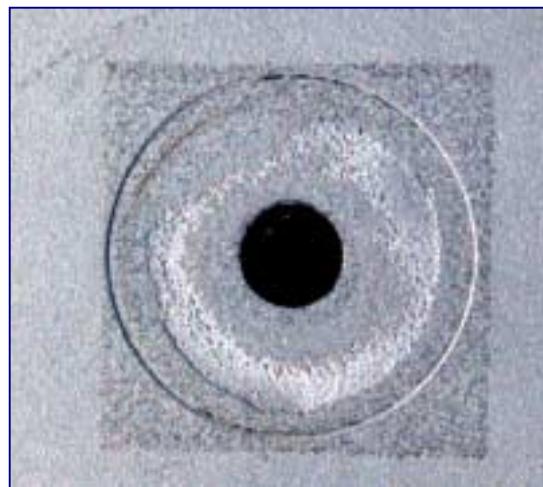
<i>Material</i>	<i># of Initiated Sites</i>	<i>Time to Initiation (days)</i>	<i>Max Depth of Attack (mm)</i>
Wrought 625	1	162	0.25
Wrought C276	0	----	0
Wrought 59	0	----	0
ESD 625	2	315(2)	0.28
ESD C276	3	280,315(2)	0.22
ESD 59	0	----	0

Ni-Cr-Mo Alloy Crevice Tests: 365 Days



ESD Alloy 625

*Max. Depth of
Attack = 0.008 in*



ESD Alloy C276

*Max. Depth of
Attack = 0.009 in.*



*Wrought Alloy 625
Control*

*Max. Depth of
Attack = 0.010 in.*

SUMMARY OF RESULTS

- ESD Coatings of Alloy 400, 70/30 CuNi, and Alloys 625, C276, and 59 Applied Using ESD
- Microhardness Evaluation of ESD Alloy 400 on K500
 - *ESD coating hardness similar to wrought Alloy 400*
 - *No thermal distortion of K500 substrate*

SUMMARY OF RESULTS

- Potentiodynamic Polarization Testing of ESD Alloy 400 and 70/30 CuNi
 - *Similar anodic polarization behavior between ESD coating and wrought counterpart*

SUMMARY OF RESULTS

- Crevice Corrosion Evaluation of ESD Ni-Cr-Mo Alloys
 - ESD Alloy 59: *No crevice corrosion initiation after 365 days, similar to wrought 59*
 - ESD Alloy 625: *Improved crevice corrosion resistance as compared to wrought 625*
 - ESD Alloy C276: *Increased crevice corrosion susceptibility as compared to wrought C276 (resistant after 365 days)*